

80830

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

6

6

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

Rev E

100

0.00

Memo

Program Batch No. 80830 Double check by: [Signature] 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-
Machine Step No 3 per Folio FA051 and insp

0.00

110

0.00

Memo

Machine keyway as per dwg D2573 & D2574

0.00

120

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80830

March-01-12 10:09:32 AM

80830

Page 2

Item ID: D2574

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Aft In 205

Stop ***NS2***

Start Date: 01/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>SC</i>	<i>12/03/12</i>		<i>6</i>	<i>0</i>		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>7h30</i> <i>320°F</i> FINISH TIME: <i>9h00</i> OVEN TEMPERATURE: <i>m120 222</i>	0.00 0.00							

6x0 m120 12/03/12

6 x m120 12/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80830

March-01-12 10:09:32 AM

80830

Page 3

Item ID: D2574

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Aft In 205

Stop *NS2*

Start Date: 01/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6 12-3-15

170

Identify as per dwg & Stock Location

5 433

0.00

170

Packaging

Memo

0.00

Packaging

6 12-03-15

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/3/15 12-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-01-12 10:09:36 AM

Page 1

Work Order ID: 80830

80830

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 01/03/2012

Required Date: 21/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	90.0000	1	6			
D6101-005									**				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT041

58

71721

1

76838

7

79588 ✓

50

MAT044

28

79874

28

MAT045

1

74507

1

MAT046

3

66966

3

12.3.2

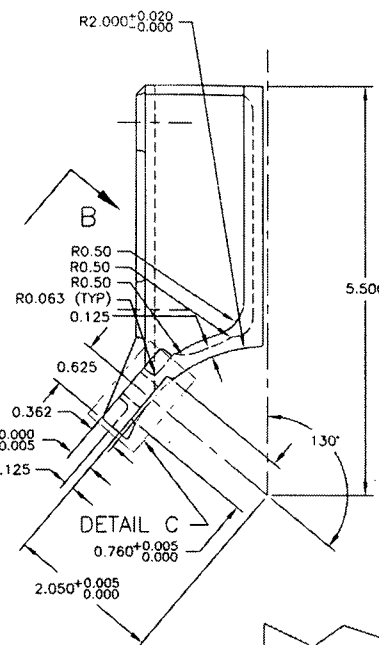
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

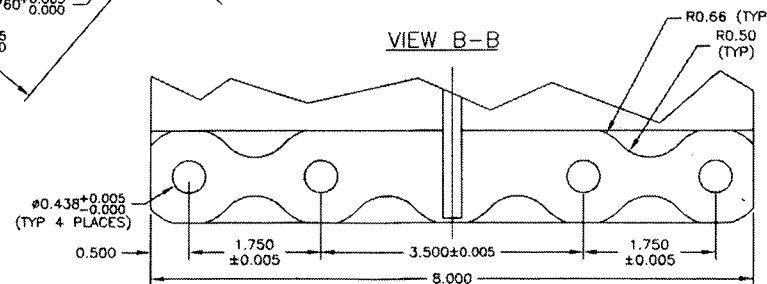
NOTE: Date & initial all entries



05.12.06




MATERIAL: 7073-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |



DETAIL C
SCALE 2:1

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/5079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
		 DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
DATE 05.07.13		DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. SHEET 1 OF 2

UNCG
SULLY

10-80830 MLS
12/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 80830
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.442	.443		
B	1.745	1.755		1.747	1.746	1.748	1.750		
C	3.495	3.505		3.496	3.495	3.497	3.499		
D	1.745	1.755		1.747	1.745	1.749	1.748		
E	7.990	8.010		8.004	8.004	8.004	8.003		
F	0.490	0.510		.502	.504	.505	.503		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		.566	.569	.570	.569		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.365	1.375		1.369	1.370	1.368	1.369		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	4.119	4.129		4.122	4.122	4.123	4.122		
P	0.115	0.135		.125	.124	.124	.126		
Q	0.115	0.135		.128	.130	.132	.130		
R	0.240	0.260		.254	.253	.254	.254		
S	0.115	0.135		.131	.170	.130	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.224	3.226	3.227	3.226		
V	0.230	0.250		.237	.236	.234	.235		
W	0.115	0.135		.129	.129	.128	.130		
X	0.307	0.312		.308	.308	.308	.308		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.362	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.629	.625		
AC	0.053	0.073		.062	.062	.062	.062		
AD	0.240	0.260		.249	.251	.247	.244		
AE	1.500	1.520		1.512	1.512	1.512	1.513		
AF	0.115	0.135		.130	.131	.131	.129		
AG	0.240	0.280		.270	.269	.267	.268		
AH	0.240	0.260		.248	.248	.246	.247		
AI	2.000	2.020		2.006	2.005	2.006	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	12/03/06 / 12/03/04

Audited by:	RF
Date:	12/05/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 80830
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	3	4		
A	0.438	0.443		0.443	0.443				
B	1.745	1.755		1.748	1.748				
C	3.495	3.505		3.498	3.498				
D	1.745	1.755		1.748	1.748				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		0.5035	0.506				
G	0.257	0.262		.258	.256				
H	0.375	0.380		.377	.377				
I	0.490	0.510		0.5038	0.5038				
J	1.174	1.184		1.178	1.179				
K	0.558	0.578		0.569	0.569				
L	1.174	1.184		1.178	1.179				
M	1.365	1.375		1.369	1.371				
N	2.495	2.505		2.499	2.499				
O	4.119	4.129		4.123	4.124				
P	0.115	0.135		.125	.123				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		.255	.252				
S	0.115	0.135		0.132	0.132				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.227	3.228				
V	0.230	0.250		0.235	0.234				
W	0.115	0.135		0.129	0.129				
X	0.307	0.312		.308	.306				
Y	0.760	0.765		.761	.761				
Z	0.352	0.372		0.362	0.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.629				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		0.246	0.245				
AE	1.500	1.520		1.510	1.512				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		.271	.272				
AH	0.240	0.260		0.248	0.248				
AI	2.000	2.020		2.000	2.005				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	JP
Date:	12/03/06/jamz

Audited by:	RF
Date:	12/03/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	